

Work Order ID 127405***127405***

Page 1

Item ID: D206-817-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/7/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: *MLS*Date: *1502-23* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI9659

A

DSI9687

A

IIN-D206-817

D

100

Document Control

0.00

1000

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-817-011 CHG006

MAR 05 2015

DAS
06
9-89*MLS**1502-23**(Signature)*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

*15-02-21*DAS
06
9-89DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127405

127405

Page 2

Monday, February 23, 2015 7:24:44 AM

Item ID: D206-817-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 1/7/2015 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120
120

QC4- 100% Inspect kits for completeness

0.00

5x

DAS
46
9-89

MAR 05 2015

QC
Quality Control

Memo

0.00

130
130

Packaging

0.00

F6
33

MAR 05 2015

5
DAS
06
9-89

Packaging
Packaging

Memo

Identify and pack for shipping as per PPP D206-817-011 Location: _____

PPP Rev: _____

0.00

140
140

QC21- Final Inspection - Work Order Release

0.00

MW 150306

QC
Quality Control

Memo

0.00

MW 150306

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Monday, February 23, 2015 7:24:50 AM

Page 1

Work Order ID: 127405

127405

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687
DD VERF:JLM IPP REV:G 15.01.06 now @ chg006/ecn14-547 DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4541-1		Manufactured	No			110	Each	22.0000	5				DAS 06 9-89
D4541-1	DAS 46 9-89								**				

Location	Loc Qty	Loc Code
ST626	22	
148995	2	
126489	8	
127095	12	

D4541-2		Manufactured	No			110	Each	21.0000	5				DAS 06 9-89
D4541-2	DAS 46 9-89								**	115 358x1			

Location	Loc Qty	Loc Code
ST626	21	
125732	4	
126491	5	
127096	12	

D4542-1		Manufactured	No			110	Each	8.0000	5				DAS 06 9-89
D4542-1	DAS 46 9-89								**				

Location	Loc Qty	Loc Code
ST628	8	
116077	3	
122802	5	

FEB 2 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 127405

127405

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

D4542-2

Manufactured No

110

Each

7.0000

5

**

DAS
66
9-89

DAS
28
9-89

S *D4542-2* DAS
Retainer, Inner, RH 46
9-89

Location

Loc Qty

Loc Code

ST628

7

7

110

Each

24.0000

5

**

DAS
66
9-89

DAS
28
9-89

D4541-3

Manufactured No

S *D4541-3* DAS
Bracket 46
9-89

Location

Loc Qty

Loc Code

ST627

24

6

6

12

110

Each

20.0000

5

**

DAS
66
9-89

DAS
28
9-89

D4541-4

Manufactured No

S *D4541-4* DAS
Bracket, RH 46
9-89

Location

Loc Qty

Loc Code

ST627

20

3

5

12

110

Each

22.0000

5

**

DAS
66
9-89

DAS
28
9-89

D4541-5

Manufactured No

S *D4541-5* DAS
Bracket, LH 46
9-89

Location

Loc Qty

Loc Code

st631

22

1

1

8

12

113219

122256

126488

127099

FEB 23 2015

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

Monday, February 23, 2015 7:24:50 AM

Work Order ID: 127405

127405

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

D4541-6
D4541-6
 Bracket, RH

DAS
46
 9-89

Manufactured No

110 Each 18.0000 5

**

DAS
66
 9-89

DAS
28
 9-89

Location	Loc Qty	Loc Code
st631	18	
115293	3	
123645	5	
127100	10	

D4541-7
D4541-7
 Bracket

DAS
46
 9-89

Manufactured No

110 Each 15.0000 5

**

DAS
66
 9-89

DAS
28
 9-89

Location	Loc Qty	Loc Code
ST635	15	
116104	2	
122362	1	
127101	12	

D4541-8
D4541-8
 Bracket

DAS
46
 9-89

Manufactured No

110 Each 20.0000 5

**

DAS
66
 9-89

DAS
28
 9-89

Location	Loc Qty	Loc Code
ST635	20	
115956	1	
123652	7	
127102	12	

D4542-3
D4542-3
 Retainer, Inner

DAS
46
 9-89

Manufactured No

110 Each 21.0000 10

**

DAS
66
 9-89

DAS
28
 9-89

Location	Loc Qty	Loc Code
ST629	21	
121013	9	
127103	12	

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Picklist Print

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Work Order ID: 127405

127405

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

D4542-5

DAS
46
9-89

Manufactured No

110

Each

14.0000

2

10

**

DAS
66
9-89

DAS
28
9-89

D4542-5
Retainer, Inner

Location

Loc Qty

Loc Code

st631

14

126360
128254

4

10

110

Each

19.0000

2

10

**

DAS
66
9-89

DAS
28
9-89

D4542-7

DAS
46
9-89

Manufactured No

D4542-7
Retainer, Inner

Location

Loc Qty

Loc Code

st631

19

116675
127104

7

12

110

Each

10.0000

1

5

**

DAS
66
9-89

DAS
28
9-89

D4543-1

DAS
46
9-89

Manufactured No

D4543-1
Retainer, LH Outer (Lower)

Location

Loc Qty

Loc Code

st630

10

126144
126486

2

8

110

Each

5.0000

1

5

**

DAS
66
9-89

DAS
28
9-89

D4543-2

DAS
46
9-89

Manufactured No

D4543-2
Retainer, Outer, RH

Location

Loc Qty

Loc Code

st630

5

125603

5

**

DAS
66
9-89

DAS
28
9-89

FEB 23 2015

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Picklist Print

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Page 5

Work Order ID: 127405

127405

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

D4543-3

Manufactured No

110 Each

6.0000

1 5

DAS
66
9-89

D4543-3

DAS
46
9-89

Retainer, Outer, LH

Location

Loc Qty

Loc Code

ST632

6

122334
126485

1

5

DAS
28
9-89

D4543-4

Manufactured No

110 Each

9.0000

1 5

DAS
66
9-89

D4543-4

DAS
46
9-89

Retainer, RH Outer (Sloc)

Location

Loc Qty

Loc Code

ST632

9

122250
126484

2

7

DAS
28
9-89

D4543-5

Manufactured No

110 Each

8.0000

1 5

DAS
66
9-89

D4543-5

DAS
46
9-89

Retainer, Outer, LH

Location

Loc Qty

Loc Code

ST634

8

122372
126483

1

7

DAS
28
9-89

D4543-6

Manufactured No

110 Each

7.0000

1 5

FEB 23 2015

D4543-6

DAS
46
9-89

Retainer, Outer, RH

Location

Loc Qty

Loc Code

ST634

7

108205
115993
123666

1

1

5

DAS
66
9-89

DAS
28
9-89

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Shop Packet Print

Page 5

Picklist Print

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Page 6

Work Order ID: 127405

127405

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

D4544-1 Manufactured No

110 Each

10.0000

1 5

D4544-1
Retainer, Center

DAS
46
9-89

**

DAS
66
9-89

Location

Loc Qty

Loc Code

ST629

10

121043
123675

1

9

1
4

DAS
28
9-89

D4594-1 Manufactured No

110 Each

8.0000

1 5

D4594-1
Plate

DAS
46
9-89

**

DAS
66
9-89

Location

Loc Qty

Loc Code

ST633

8

126482

8

5

DAS
28
9-89

D4595-150-13 Manufactured No

110 Each

346.0000

2 10

D4595-150-13
Sealant Tape (13' Long)

DAS
46
9-89

**

DAS
66
9-89

Location

Loc Qty

Loc Code

MF

346

119766

346

475

DAS
28
9-89

AN525-10R7 Purchased No

110 Each

452.0000

95 475

AN525-10R7
SCREW

DAS
46
9-89

**

DAS
66
9-89

Location

Loc Qty

Loc Code

ST325A

200

m131305

200

ST329

252

112411

9

113288

29

115371

38

m128429

176

200
9
29
36
159

DAS
28
9-89

FEB 21 2015

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Shop Packet Print

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Picklist Print

Page 7

Monday, February 23, 2015 7:24:51 AM

Work Order ID: 127405

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

127405

D206-817-011

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

MS20426AD3-4

Purchased

No

110

Each

2,106.000

190

950

MS20426AD3-4

RIVET

DAS
46
9-89

**

DAS
66
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

12

125578

12

GA

1720

m127432

1720

595

MF4

36

125578

36

17

ST313

338

125578

338

355

MS21059L08

Purchased

No

110

Each

504.0000

143

215

MS21059L08

Nut

DAS
46
9-89

**

DAS
66
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

MF4

74

125654

74

ST302

430

m129934

110

110

m131317

120

105

m131624

200

FEB 23 2015
DAS
28
9-89

Monday, February 23, 2015 7:24:51 AM

Shop Packet Print

Page 7

Picklist Print

Monday, February 23, 2015 7:24:51 AM

Page 8

Work Order ID: 127405

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

127405

D206-817-011

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

MS21059L3K

Purchased

No

110

Each

1,146.000

93

465

DAS

MS21059L3K

DAS

46

Nutplate

9-89

**

11823-1x10

DAS

46

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

205

m127635

205

ST273A

700

cm131618

700

ST303

241

10 t

m129913

241

MS210611.08

Purchased

No

110

Each

86.0000

10

50

DAS

46

9-89

DAS

28

9-89

MS210611.08

DAS

46

Nutplate

9-89

**

114x m 130799

Location

Loc Qty

Loc Code

ST302

86

m128635

11

m130799

25

m131387

50

11

DAS

46

9-89

DAS

28

9-89

MS21075L08

Purchased

No

110

Each

137.0000

2

5

DAS

46

9-89

DAS

28

9-89

MS21075L08

DAS

46

ANCHOR NUT

9-89

**

1314207

Location

Loc Qty

Loc Code

ST300

137

M128635

137

MS27039-08-10

Purchased

No

110

Each

1,193.000

42

210

DAS

46

9-89

DAS

28

9-89

MS27039-08-10

DAS

46

Screw

9-89

**

210

Location

Loc Qty

Loc Code

ST281

1193

m128799

1193

FEB 23 2015

Monday, February 23, 2015 7:24:52 AM

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Page 8

Picklist Print

Monday, February 23, 2015 7:24:52 AM

Page 9

Work Order ID: 127405

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

127405

D206-817-011

Start Date: 12/29/2014

Required Date: 1/7/2015

Start Qty: 5.00

Required Qty: 5.00

NAS1149DN832J

Purchased

No

110

Each

1,058.000

42. 210

NAS1149DN832J

DAS

46

Washer

9-89

**

DAS

06

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST270

789

124555

15

M128429

74

M131317

600

M131624

100

64
45
100

MS21061L3K

Purchased

No

110

Each

70.0000

2 10

MS21061L3K

DAS

46

NUT PLATE

9-89

**

FEB 23 2015

DAS

06

9-89

Location

Loc Qty

Loc Code

GA

56

125268

6

m131467

50

ST302

14

123603

14

10

DAS

28

9-89

Monday, February 23, 2015 7:24:52 AM

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Page 9

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

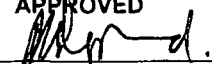
INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 13.06.20
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	OS	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	OS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OS		
CHECKED	140	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	OS	TITLE	SCALE
DE APPR.	11	SEALANT TAPE	NTS
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15-02-23
127405-ML5
RETURN TO
DRAWING
COPY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2

REF. TCCA STC SH12-3
REF. FAA STC SR03091NY
REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
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3.0 INSTALLATION

IF INSTALLING A D206-817-011 KIT AT CHG 005 OR LATER, STEP 3.3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV D IS MODIFIED AS FOLLOWS:

- 3.3 Install Dart inner retainers. It is acceptable to hand form retainers as required to allow fit. Retainers should be located so that they are approximately flush with the aircraft skin. Locate retainers and transfer drill Ø0.128" from aircraft frame. Locate as follows, using Figure 3-2 as reference:
- a) Locate D4541-1/-2 Brackets along the bottom window frame flush against the door pillars. The Bracket should be oriented with the hole pattern for the MS21061L3K nutplate (the non-symmetric nutplate, ref) near the door post. See Figure 3-3 for reference.
 - b) Locate D4541-3/-4 Brackets on the door pillars, above the -1/2 Brackets. See Figure 3-3.
 - c) Locate D4541-5/-6 Brackets above the -3/-4 retainers. See Figure 3-4.
 - d) Locate D4541-7/-8 Brackets along the top edge, with one side aligned with the center column. See Figure 3-4.
 - e) Relocate the 206-031-112-039 (or equiv.) clip removed at step 3.2(g) per Figure 3-3.

Install brackets wet with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 sealant between retainers and a/c frame. Fasten D4541-1/-2 Lower Inner Brackets with CR3214-4 (or NAS9301B or M7885/2) rivets and NAS1149DN432J (or 140-001-1 or AN960JD4 or equiv.) washers. Fasten D4541-X Brackets with MS20600AD4 rivets. Reinstall clip (206-031-112-039 or equiv.) with CR3213-4 rivets. See Figure 3-3 for reference.

*Note: Due to variations in airframes the D4541-X Brackets have been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

- 3.4 Locate D4542-X Retainers onto the D4541-X Brackets as follows, see Figures 3-3 & 3-4 for reference:

- a) Locate D4542-1 Retainers onto the D4541-1/-2 Brackets
- b) Locate D4542-3 Retainers onto the D4541-3/-4 Brackets
- c) Locate D4542-5 Retainers onto the D4541-5/-6 Brackets
- d) Locate D4542-7 Retainers onto the D4541-7/-8 Brackets

Hand form D4541-X Brackets and/or D4542-X as required to fit profile of windshield. Locate and transfer drill rivet holes to D4542-X Retainers and open to Ø0.098. Locate and transfer drill screw holes and open to Ø0.250". Dimple the Ø0.098 holes Ø0.180 x 100° and install MS21059L3K nutplates with MS20426AD3-4 rivets.

*Note: Due to variations in airframes the D4542-5 Retainer has been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

FIGURES 3-2 & 3-3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D ARE MODIFIED AS SHOWN ON SHEETS 3 AND 4 OF THIS SERVICE INSTRUCTION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	14.03.18
CERT. NO.:	SH12-3
ISSUE NO.:	1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER KIT	NTS
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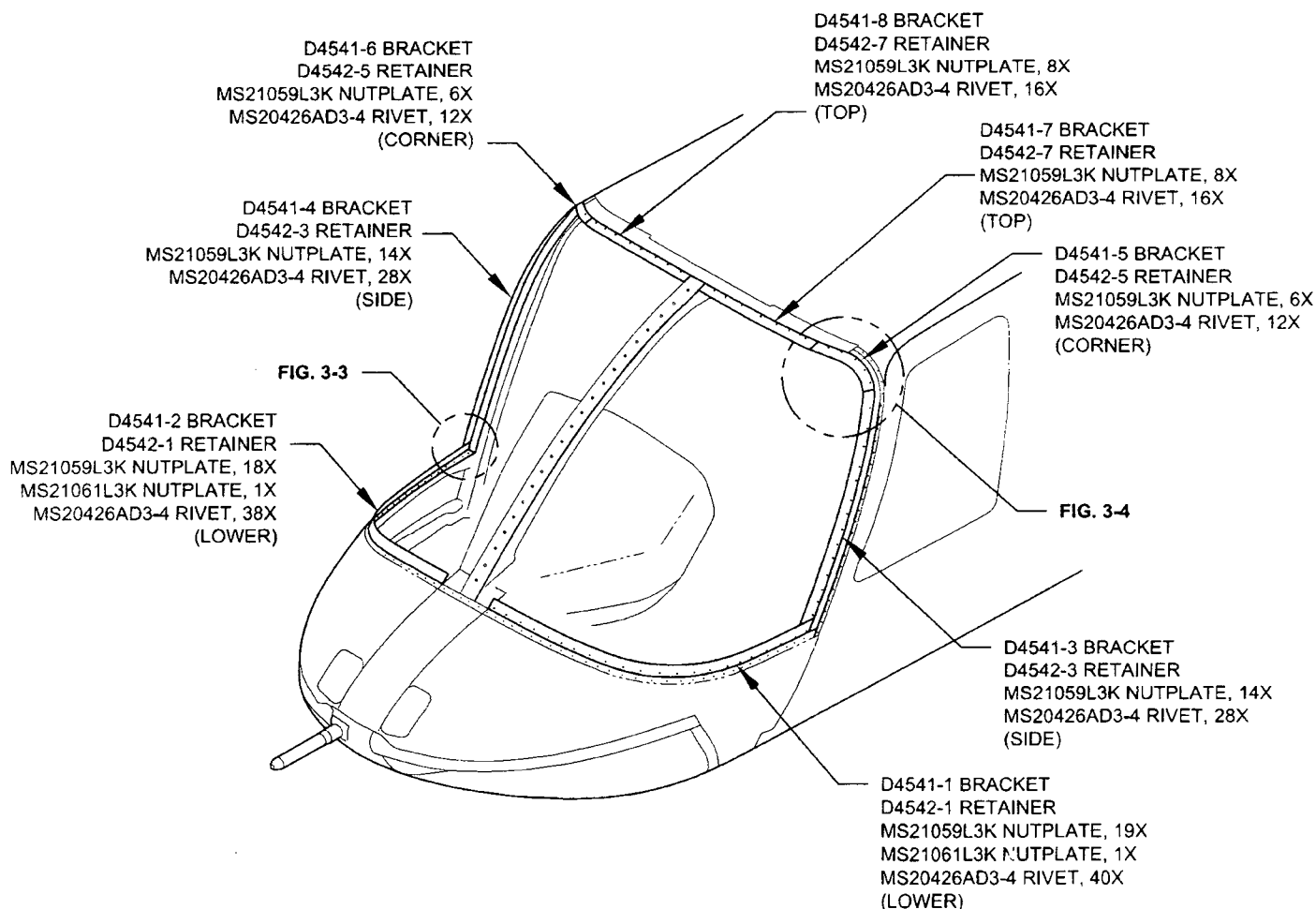


FIGURE 3-2
(REF IIN-D206-817 REV D)

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER KIT	NTS
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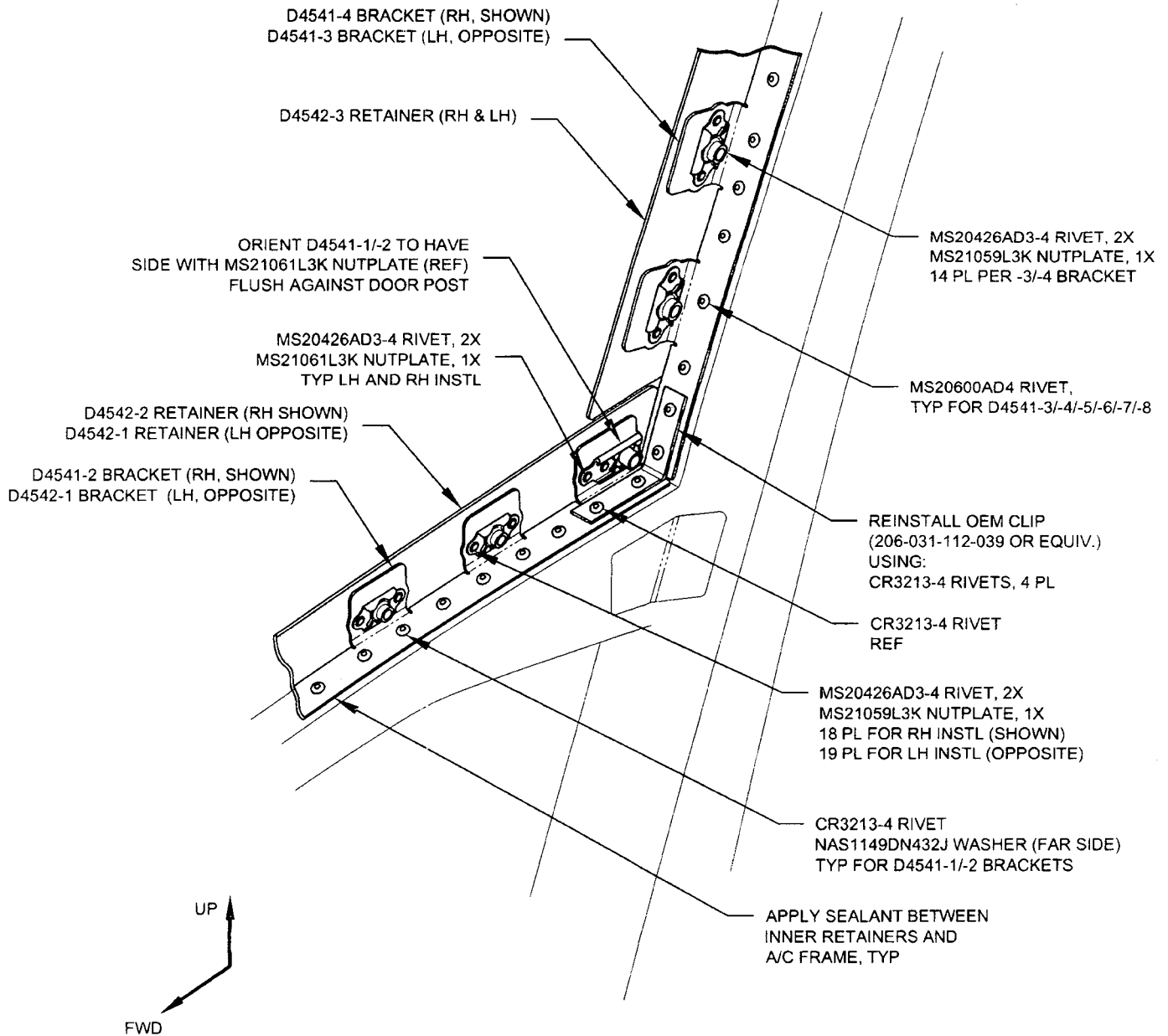


FIGURE 3-3
(REF IIN-D206-817 REV D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER KIT	NTS
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REFERENCE ONLY

DART AEROSPACE LTD.

MAR 05 2015

IIN-D206-817

DAS

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4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-3	BRACKET, LH
1	D4541-4	BRACKET, RH
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
1	D4541-7	BRACKET, LH
1	D4541-8	BRACKET, RH
2	D4542-3	RETAINER, INNER
2	D4542-5	RETAINER, INNER
2	D4542-7	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4543-5	RETAINER, LH OUTER (SIDE)
1	D4543-6	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
10	MS21061L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)

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Revision: D

Date: 13.04.15

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2

REF. TCCA STC SH12-3

REF. FAA STC SR03091NY

REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
12	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.18

CERT. NO.: SH12-3

ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 13.06.20
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	OS	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	OS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OS		
CHECKED	NO	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	SEALANT TAPE	NTS
DATE	13.06.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	